

Work Order ID 74456

Wednesday, October 05, 2011 11:15:38 AM

Page 1

Item ID: D3806-5

Accept

Revision ID:

Item Name: Bar

Start Date: 9/29/2011 Start Qty: 20.00

Required Date: 10/20/2011 Req'd Qty: 20.00

Reference:

Approvals: Process Plan: *W*

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3806

B

100

0.00



Cold Saw

0.00

Hyd Mech

Memo

Cut blanks at 44.00"

FOR CLAMPING PURPOSE WHEN WELDING .500" WAS ADDED ON LENGTH AND IT WILL BE CUT TO LENGTH AFTER WELDING

110

0.00



HAAS I

0.00

HAAS CNC vertical machine #1

Memo

1-Mill as per folio FB070 & dwg

FOLIO REV: *FA*

DWG REV: *13*

2-Deburr as required



Setup Start



Stop



Cust Item ID:

Customer:



cmh 11/10/13

20 #

FK
20 11. 10. 14

20 #

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 74456

Wednesday, October 05, 2011 11:15:38 AM



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Item ID: D3806-5

Accept



Setup Start



Revision ID:

Stop



Item Name: Bar

Start Date: 9/29/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 10/20/2011 Req'd Qty: 20.00

Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

1-FK
20 11.10.14

20 φ

QC

Memo

0.00

Quality Control

FOR CLAMPING PURPOSE WHEN WELDING .500" WAS ADDED ON LENGTH AND IT WILL BE CUT TO LENGTH AFTER WELDING

130

QC8- Inspect parts - second check

0.00

B.A 11/10/17

20 φ

QC

Memo

0.00

Quality Control

140

Identify as per dwg & Stock Location: W/A

0.00



Packaging

Memo

0.00

Packaging

SL 11-10-17 (220)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 74456

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Wednesday, October 05, 2011 11:15:38 AM

Item ID: D3806-5

Accept



Setup Start



Revision ID:

Stop



Item Name: Bar

Start Date: 9/29/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 10/20/2011 Req'd Qty: 20.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11-10-20
20

11/10/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, October 05, 2011 11:15:34 AM

Page 1

Work Order ID: 74456

Parent Item: D3806-5

Parent Item Name: Bar



Start Date: 9/29/2011

Required Date: 10/20/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev:A 08-07-21 new issue DD verified by:ec
IPP Rev:B 08-09-23 redesign DD verified by:EC
IPP Rev:C 08-12-05 chg mat. thickness DD verified by:EC IPP Rev:D
11.10.04 rev.b as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B0.500X2.500		Purchased	No			100	f	13.0870	3.666	77.17895			



304 BAR .500 x 2.50



Location	Loc Qty	Loc Code
MAT050	13.087	
112764	8.312	
116135	0.375	
117685	4.4	

M119159 x 80' *on 10/13*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

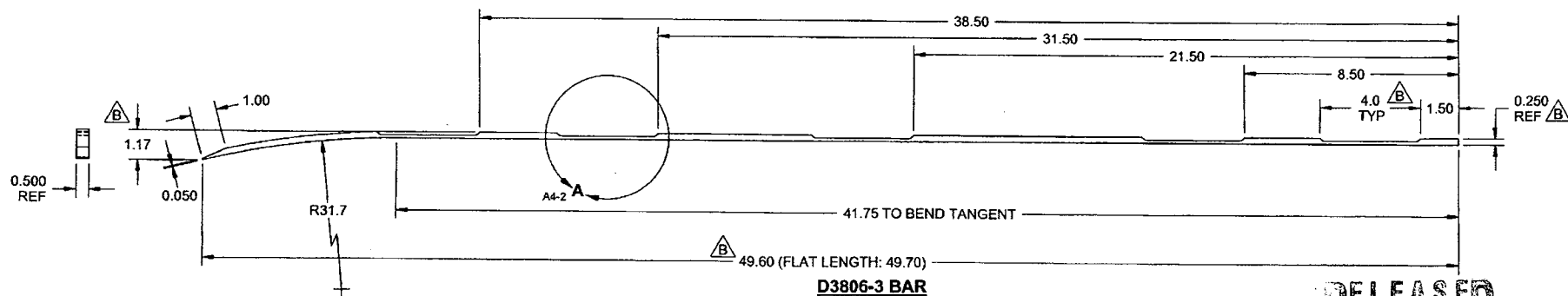
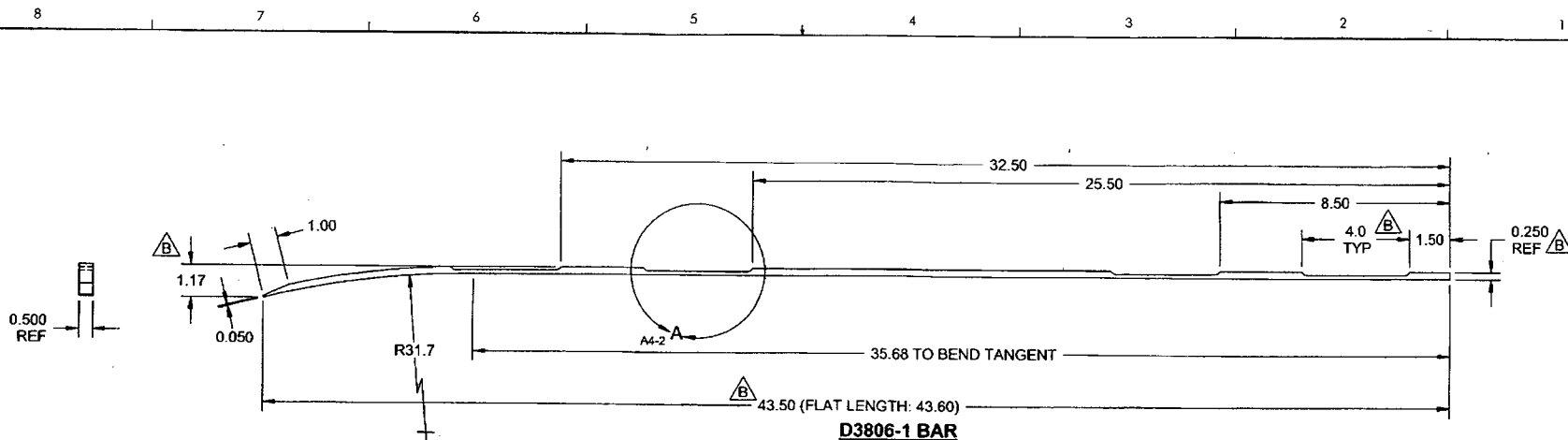
NOTE: Date & initial all entries

FIRST ARTICLE INSPECTION CHECKLIST

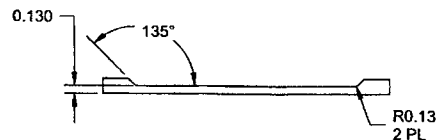
Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15





- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR, 0.250 X 0.500 THICK REF. DART SPEC. M304B0.250W00.500
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT:
D3806-1 = 1.27 lbs
D3806-3 = 1.42 lbs

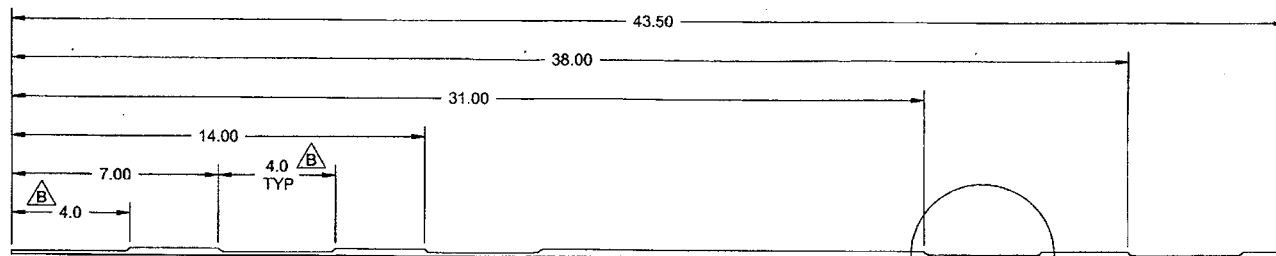
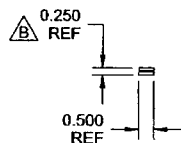


DETAIL A
TYP, SCALE 2X

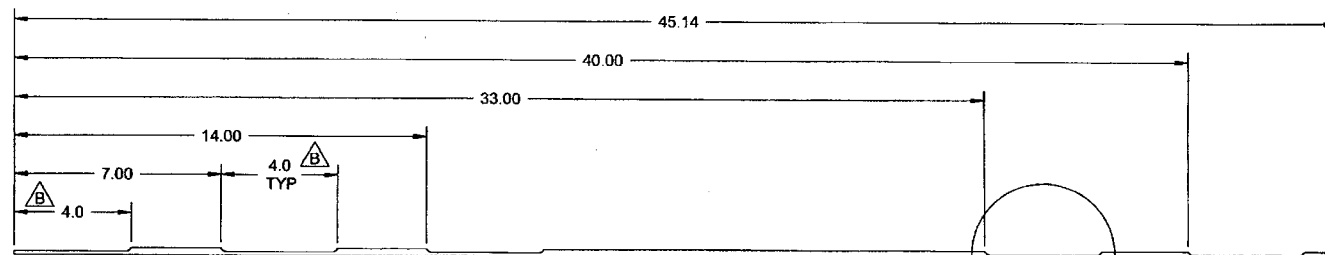
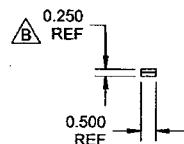
D5-2
B6-2
C3-3
A3-3

DESIGN		DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO. D3806	REV. B
MFG. APPR.		SHEET 2 OF 3	
APPROVED		TITLE	SCALE
DE APPR.		BAR	NTS
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RELEASED
2011-10-03
JH



D3806-5 BAR



D3806-7 BAR

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR, 0.250 X 0.500 THICK REF. DART SPEC. M304B0.250W00.500
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT:
D3806-5 = 1.22 lbs
D3806-7 = 1.28 lbs

RELEASED
2011-10-03

DESIGN		DART AEROSPACE USA, INC.
DRAWN		KENT, WA
CHECKED		DRAWING NO. D3806
MFG. APPR.		REV. B
APPROVED		TITLE BAR
DE APPR.		SCALE NTS
DATE	11.09.29	

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